

Work Order ID 51762

September 2, 2009 10:22:24 AM



Page 1

Item ID: D350-636-012

Accept



Setup Start



Revision ID: F

Stop



Item Name: Skidtube RH

Start Date: 09/02/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/28/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan: mf

Date: 09-09-02 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2750

Rev F

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-012 CHG 004

Sos/10/09

110

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end □ 2-Drill pilot holes as per Dwg D2750 sheet 5 (D2750-2 details). Drill using drill Jig DT8150 & DT8863. □ 3- Mark fwd end for cutting using Drill Jig

AIR M11/999

*BE 09/10/19
D 9-10-19*

120

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

DSos/10/09

(P) f

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

2/8/09/10/19



140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

1 0 - AW 9-10-20

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

2/8/09/10/23



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Stop

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--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

160

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750. 2-Open up holes of Detail K to 0.750" (total of 4 holes per side) as per dwg D2750. 3-Open float holes to .500" (4 per Side) 4-Chamfer holes of Detail

AR M111999 BE 09/10/01

SEE ATTACHED
SHEET →

170

0.00



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

Memo

0.00

2) 801/10/23



f

180

0.00



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

2) 801/10/23



φ

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REFERENCE ONLY

B-51762

REFERENCE ONLY

SEA 160

1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

2-Open up holes of Detail K to 0.750" (total of 4 holes per side)

as per dwg D2750.

3-Open float holes to .500" (4 per Side)

4-Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)

5-Deburr and blow out all chips from inside of tube

6-Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R

Sikaflex-291

batch:

M112391

AWM
9-10-20

exp. date:

10-02-20

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004

(welding instructions on sheet 9)

A/R

Aluminum Rod

batch:

M111999

BB 9-10-21

9-Grind welds flush as per Dwg D2750

AWM 9-10-22

10-Spot face ground handling holes section (total of 4 places per side) as per dwg D2750

AWM

11- At section AJ-AJ drill out x-bolt spacer to 0.404"

9-10-23

12-Deburr holes

AWM 9-10-23

REFERENCE ONLY

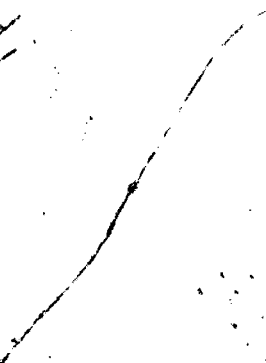
REFERENCE ONLY

B-21067

16

21

10/11/21



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Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Pressure Wash per QSI005 4.3

0.00

⇒ JH

09/10/26

X1

0



HandFinish

Memo

0.00

Hand Finishing

200

White Gloss(Ref.4.3.5.1) per QSI005 4.3-Alum

0.00

11/12260

⇒ JH

09/10/26

X1

0



Powdercoat

Memo

0.00

Powder Coating

START TIME: 10:30AM □ OVEN TEMPERATURE:
11:00 □ FINISH TIME: 320°F

210

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

Inspect for foreign object per QSI 024

Umo

09/10/27

X1

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220

0.00



HandFinishing

HandFinish

Memo

0.00

MD 09/10/27

X1

Hand Finishing

Install inserts as per dwg D2750

230

0.00



HandFinishing

HandFinish

Memo

0.00

X1

Hand Finishing

1-Inspect for Foreign Objects ☐ 2-Spray inside of tube with "LPS-3"

☐

batch: 2/1 ☐ 3-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241 ☐ BATCH: M112391 ☐ EXP DATE: 10/20 ☐ 4- assemble o'ri

LPS PROCYON: BATCH 8 M104251

MD 09/10/28

240

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

=> Seal tube

(X)

Quality Control

W/O:		WORK ORDER CHANGES					
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

9/10/08

Rsf

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

2) 80% 10/12/08

Rsf

Rsf

270

Packaging

0.00



Packaging

Memo

0.00

Packaging

Package as per PPP D350-636-012

100% REV G

9/10/08

Rsf

51762

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

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Customer:

Reference:

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/02

U 99-10-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

September 2, 2009 10:22:24 AM

Page 1

Work Order ID: 51762

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH


Comments:

Start Date: 09/02/2009

Required Date: 09/28/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
ALS4-1032-225		Purchased	No			230	Each	8,787.000	38.0000			
												
Insert												

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

8787

107441

16

110768

8771

AN3C5A

Purchased

No

230

Each

646.0000

34.0000

Bolt

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

646

111424

8

111707

338

112314

200

112489

100

AN3C6A

Purchased

No

230

Each

1,048.000

4.0000

BOLT

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

1048

110372

72

111982

976

X 38 umo 09/10/27

X 2

MD 09/10/27

X 30

X 4 mp 09/10/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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September 2, 2009 10:22:24 AM

Page 2

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Parent Item Name: Skidtube RH



Start Date: 09/02/2009

Required Date: 09/28/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN6C44A  BOLT		Purchased	No			230	Each	172.0000	4.0000 			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG	2	
103964	2	
Main Warehouse		
ST	170	
110105	4	
110155	14	
110665	1	
110865	51	
111605	50	
111649	50	

112720

X4 MD 09/10/27

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---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------


AN8C21A		Purchased	No			260	Each	112.0000	2.0000			
<div style="display: flex; justify-content: space-between;"> <div>  <p>BOLT</p> </div> <div> <p>9/10/08 SP</p> </div> </div>												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	112	
105160	1	
107596	1	
107924	2	
109092	2	
110341	2	
110342	4	
111605	50	
111684	50	

AN8C35A		Purchased	No			230	Each	167.0000	1.0000			
<div style="display: flex; justify-content: space-between;"> <div>  <p>BOLT</p> </div> <div> <p>2 50</p> </div> </div>												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	167	
102180	1	
106896	1	
110105	65	
110847	100	

XI MD 09/10/08

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960C10L  washer		Purchased	No			230	Each	2,500.000	38.0000			

Warehouse Loc Qty Loc Code

Location

OFFSHORE

FG

100

103585

100

Main Warehouse

FP

-44

112116

-44

Main Warehouse

ST

2444

112116

2444

AN960C816L

Purchased

No

230

Each

330.0000

1.0000



WASHER

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

330

104093

2

107520

4

110139

29

110372

36

110584

100

111424

159

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Shop Packet Print

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AN960C816L WASHER		Purchased	No			260	Each	330.0000	2.0000		9/10/2009	SP

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	330	
104093	2	
107520	4	
110139	29	
110372	36	
110584	100	
111424	159	

D2600-3-BENTRevD1 Extrusion Bent		Manufactured	No			110	Each	0.0000	1.0000		3 52346	BE09/10/19
D2739RevD 350 I Beam		Manufactured	No			160	Each	6.0000	1.0000			

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
LG	4	
50353	4	
Main Warehouse		
ST	2	
47124	1	
47681	1	

52305 ALM 9-10-20

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Shop Packet Print

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---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2741RevC

Manufactured

No

260

Each

40.0000

1.0000



Blade, 350 Skidtube



9/10/08 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

40

20770

0

45320

1

47113

39

1 SP

D2743RevB

Manufactured

No

220

Each

294.0000

8.0000



Crossbolt Spacer



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

50

50281

50

Main Warehouse

ST

244

44891

2

45555

177

48275

65

8 BE 09/10/01

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 51762

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH


Comments:

Start Date: 09/02/2009

Required Date: 09/28/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2744RevC 		Manufactured	No			160	Each	50.0000	1.0000			
Cap												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 50

44892 15

47488 35

D2745RevB



Bushing

Manufactured No

230 Each 272.0000 8.0000



Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 272

34817 2

36230 8

37303 1

39587 2

40726 2

41114 2

42778 19

43754 2

44893 37

45556 69

46695 18

48278 110

1 BE 09/10/19

X8 mp 09/10/27

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 51762

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH

Comments:

Start Date: 09/02/2009

Required Date: 09/28/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3488-042RevB Manufactured No

230

Each

9.0000

1.0000



Blade Fitting Assembly, RH

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

29043

44531

52000

9

1

8

160

Each

165.0000

4.0000

X1 MD 09/10/27

D3490-1RevA

Manufactured No



Cross Bolt Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

45338

47118

47657

48277

165

2

4

50

109

4 BC 09/10/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 51762



Parent Item: D350-636-012RevF



Parent Item Name: Skidtube RH

Start Date: 09/02/2009

Required Date: 09/28/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3490-3RevA Cross Bolt Spacer		Manufactured	No			160	Each	112.0000	4.0000			

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 112

45560 22

47471 35

48276 55

D3492-041RevC Manufactured No

Plug Assembly

230 Each 3.0000 8.0000



Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 3

43816 3

D3492-043RevC Manufactured No

Plug Assembly

230 Each 0.0000 8.0000



4 AC 09/10/21

X8 MD 09/10/27

X8 MD 09/10/27

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

September 2, 2009 10:22:24 AM

Work Order ID: 51762

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH

Comments:

Start Date: 09/02/2009

Required Date: 09/28/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3493-1RevA

Manufactured

No

260

Each

115.0000

2.0000



Washer

9/10/09 sf

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

115

44902

15

47710

100

2 sf

D3532-1RevA

Manufactured

No

110

Each

43.0000

2.0000



Spacer

9/10/09 sf

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

43

38161

2

44904

41

2 sf

D3535-25RevB

Manufactured

No

230

Each

11.0000

1.0000



Wearshoe

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

11

47523

11

XL md 09/10/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 51762

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH



Comments:

Start Date: 09/02/2009

Required Date: 09/28/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3536-25RevA 		Manufactured	No			230	Each	21.0000	1.0000			
Gasket												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

21

45569

1

47011

2

47526

8

50266

10

X1 MD 09/10/27

D3537-1RevC

Manufactured No

230

Each

46.0000

3.0000



Wearpad



Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

46

48288

3

50321

43

X3 MD 09/10/27

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

September 2, 2009 10:22:24 AM

Work Order ID: 51762

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH


Comments:

Start Date: 09/02/2009

Required Date: 09/28/2009


Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3631-1RevA  Washer		Manufactured	No			230	Each	105.0000	8.0000			

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse	51908	
ST	105	
38139	6	
45353	16	
47437	83	

Y8 mp 09/11/09/27

D3791-1RevA  Wearplate		Manufactured	No			230	Each	18.0000	1.0000			
--	--	--------------	----	--	--	-----	------	---------	--------	--	--	--

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse	51610	
ST	18	
47536	8	
50269	10	

XL mp 09/11/09/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

September 2, 2009 10:22:24 AM

Work Order ID: 51762

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH


Comments:

Start Date: 09/02/2009

Required Date: 09/28/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3793-1RevA  Wearshoe		Manufactured	No			230	Each	18.0000	1.0000			

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

40551

47537

50231

18

1

4

13

230

Each

22.0000

1.0000

XL mp 09/10/23

D3793-3RevA



Wearshoe

Manufactured

No

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

47720

50216

22

11

11

XL mp 09/10/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 51762



Parent Item: D350-636-012RevF



Parent Item Name: Skidtube RH

Start Date: 09/02/2009

Required Date: 09/28/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3794-1RevA		Manufactured	No			230	Each	7.0000	1.0000			
Gasket												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

51608

ST

7

46530

1

47212

2

47721

4

21 MD 09/10/27

D3794-3RevA

Manufactured No

230

Each

27.0000

1.0000



Gasket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

27

46531

2

47440

2

47722

11

50240

12

21 MD 09/10/27

September 2, 2009 10:22:24 AM

Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE:- Date & initial all entries

Picklist Print

September 2, 2009 10:22:24 AM

Work Order ID: 51762

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH


Comments:

Start Date: 09/02/2009

Required Date: 09/28/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21043-6  NUT		Purchased	No			230	Each	1,132.000	4.0000			

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 1132

110584 34

111424 98

112314 1000

X4 MD 09/10/27

MS21083C8



NUT

Purchased

No

230

Each

92.0000

1.0000

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 92

110584 5

111424 2

111637 21

112243 44

112492 20

X1 MD 09/10/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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September 2, 2009 10:22:24 AM

Work Order ID: 51762

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH


Comments:

Start Date: 09/02/2009

Required Date: 09/28/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21083C8  NUT		Purchased	No			260	Each	92.0000	2.0000			

9/10/28 SP

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

92

110584

5

111424

2

111637

21

112243

44

112492

20

2 SP

NAS1515H3L



WASHER

Purchased

No

260
230

Each

350.0000

4.0000



Warehouse
Location

Loc Qty

Loc Code

OFFSHORE

FG

40

102472

40

Main Warehouse

ST

310

110450

2

110806

8

111819

300

14 MD 09/10/27

September 2, 2009 10:22:24 AM

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 17

September 2, 2009 10:22:24 AM

Work Order ID: 51762

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH

Comments:

Start Date: 09/02/2009

Required Date: 09/28/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

NAS1515H8L

Purchased

No

260

Each

129.0000

2.0000



WASHER

9/10/09 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

129

107581

34

108964

1

111650

94

NAS1611-010

Purchased

No

230

Each

345.0000

8.0000



O-RING

2 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

345

110715

50

110915

295

P70

September 2, 2009 10:22:24 AM

Shop Packet Print

Page 17

W/O: 51762		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09/10/27		Replaced O-Ring was 1611-010 by O-Ring D2594-3 Batch: BS1613	MD	09/10/27	18		S 09/10/28

Part No: D350-636-012 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 18

September 2, 2009 10:22:24 AM

Work Order ID: 51762

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH


Comments:

Start Date: 09/02/2009

Required Date: 09/28/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS1611-013  O-RING		Purchased	No			230	Each	320.0000	8.0000			

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

320

106513

11

111424

109

111758

200

X8 MP 09/10/27

September 2, 2009 10:22:24 AM

Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

SHOP COPY
RETURN TO
ENGINEERING
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 51762 MF 09-09-02

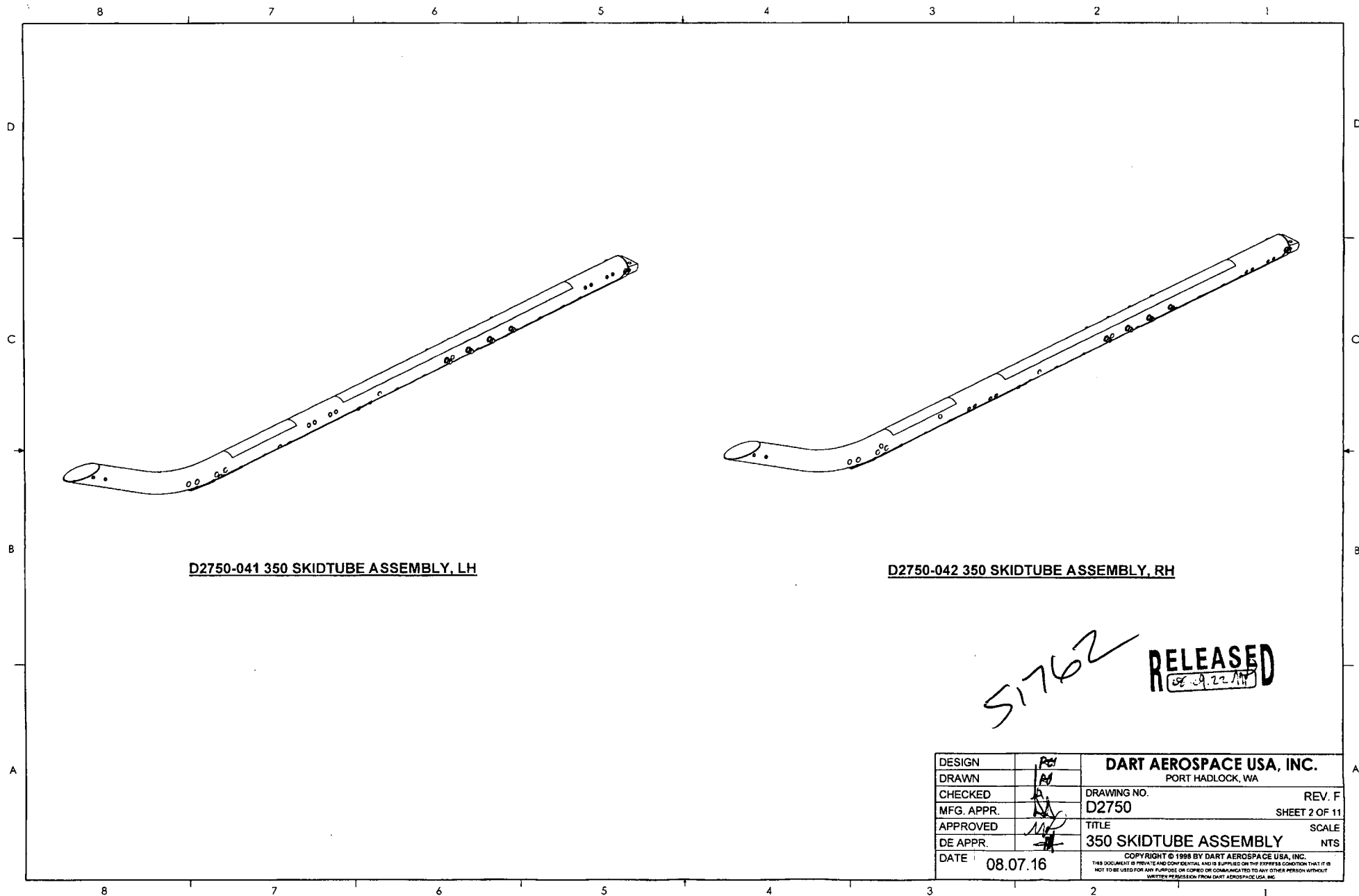
RELEASED

GENERAL NOTES:

- 1) MATERIAL: MAKE D2750-1/2/3/4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- 8) WELD PER DART QSI 004
- 9) INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- 10) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 11) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS:
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- 13) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3536-13/35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AST SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515HBL; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/8157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	PC		
DRAWN	RL		
CHECKED	LL		
MFG. APPR.	LL		
APPROVED	LL		
DE APPR.	LL		
DATE	08.07.16		

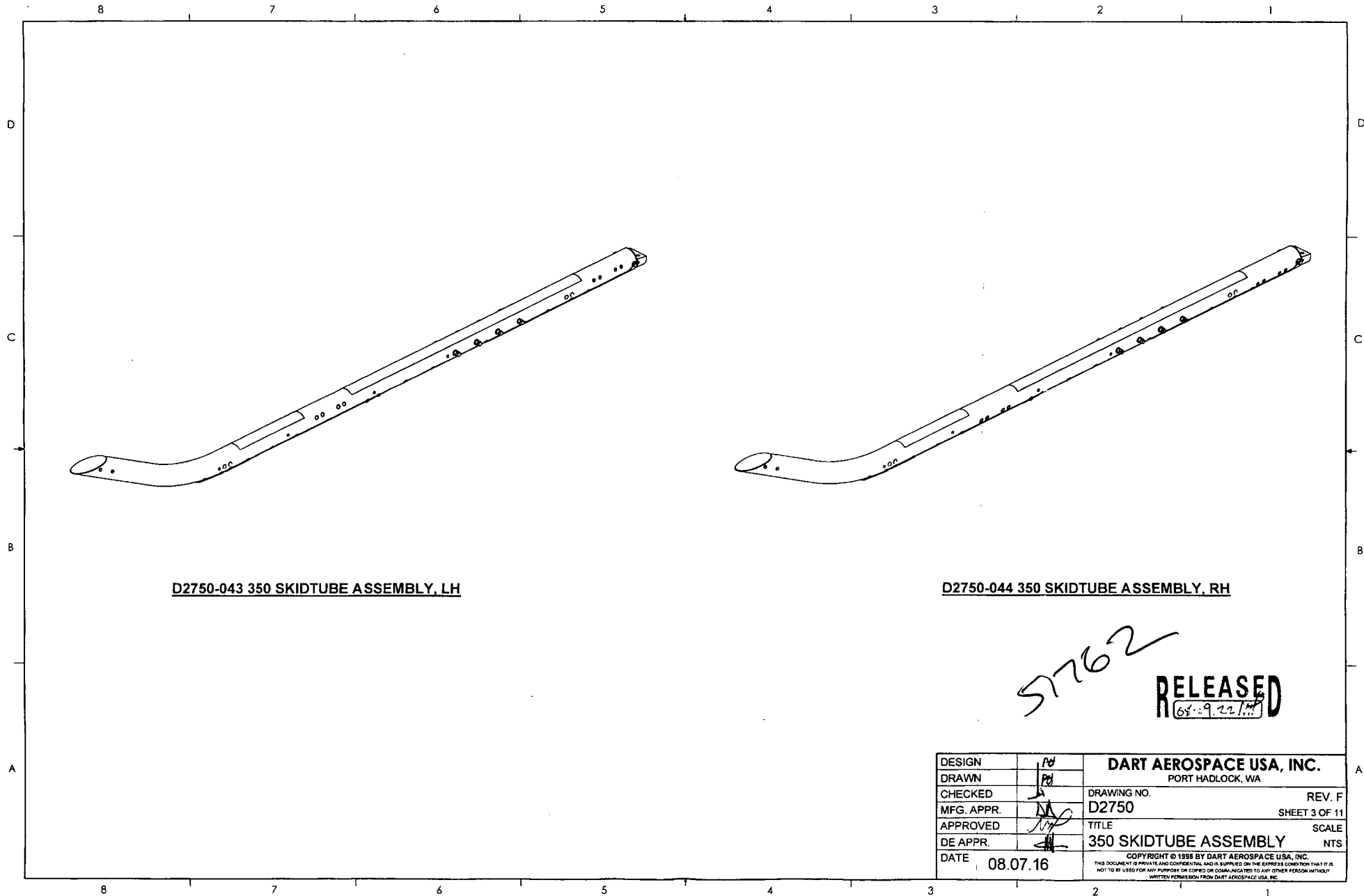
DART AEROSPACE USA, INC.	
PORT HADLOCK, WA	
DRAWING NO.	REV. F
D2750	SHEET 1 OF 11
TITLE	SCALE
350 SKIDTUBE ASSEMBLY	NTS
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CHECKED	AM	DRAWING NO.	REV. F
MFG. APPR.	AM	D2750	SHEET 2 OF 11
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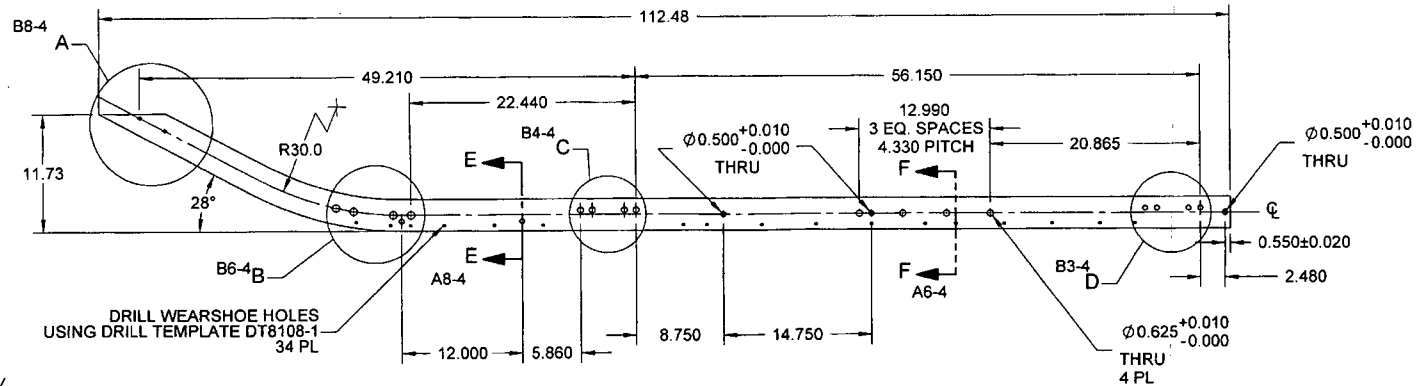
D2750-043 350 SKIDTUBE ASSEMBLY, LH

D2750-044 350 SKIDTUBE ASSEMBLY, RH

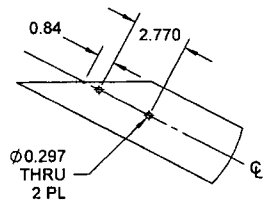
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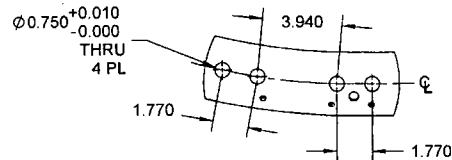
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DRAWN	PD	PORT HADLOCK, WA	
CHECKED	NA	DRAWING NO.	REV. F
MFG. APPR.	NA	D2750	SHEET 3 OF 11
APPROVED	NA	TITLE	SCALE
DE APPR.	NA	350 SKIDTUBE ASSEMBLY	NTS
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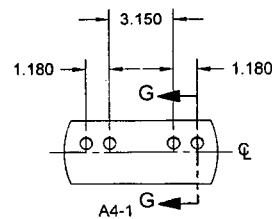
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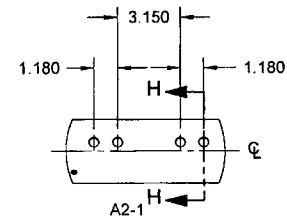
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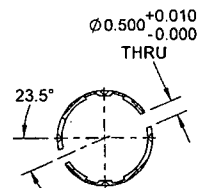
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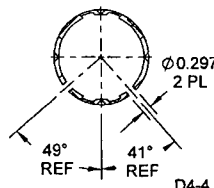
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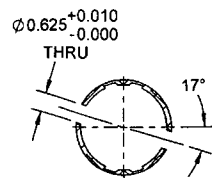
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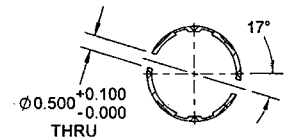
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL



SECTION H-H
SCALE 3X, 4 PL

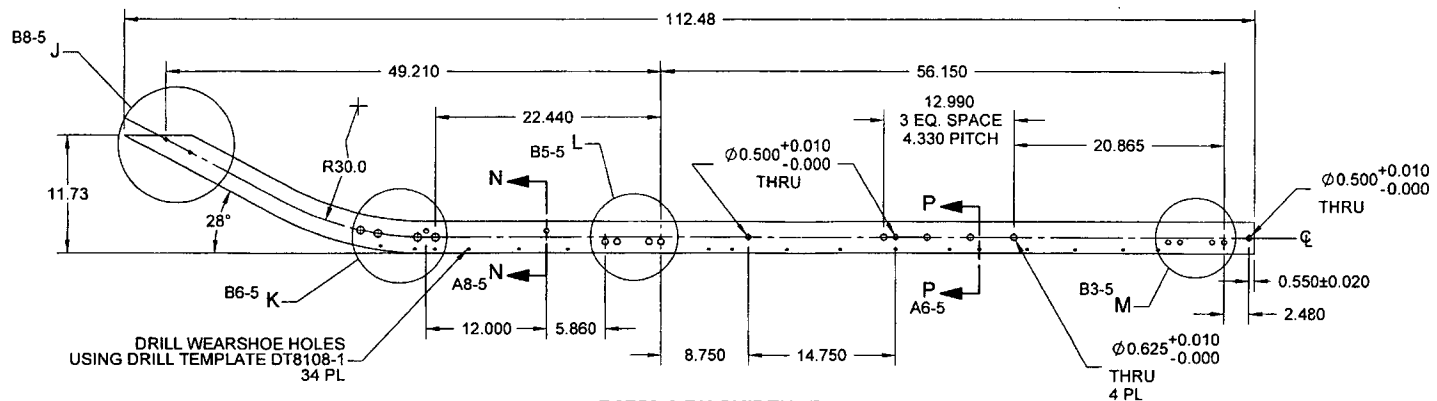
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CHECKED	101
MFG. APPR.	101
APPROVED	101
DE APPR.	101
DATE	08.07.16

DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWING NO. D2750	REV. F
TITLE 350 SKIDTUBE ASSEMBLY	SHEET 4 OF 11
DATE 08.07.16	SCALE NTS

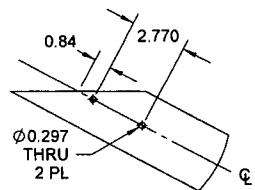
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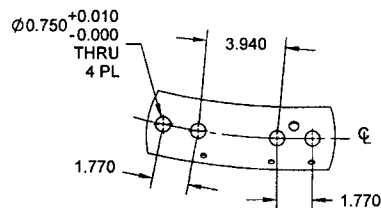
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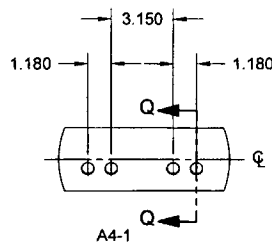
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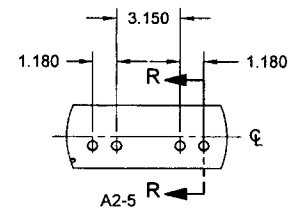
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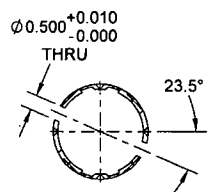
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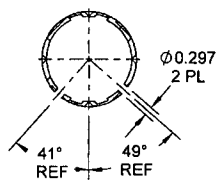
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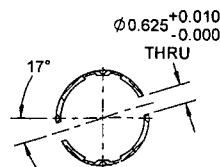
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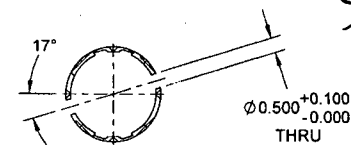
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL



SECTION R-R
SCALE 3X, 4 PL

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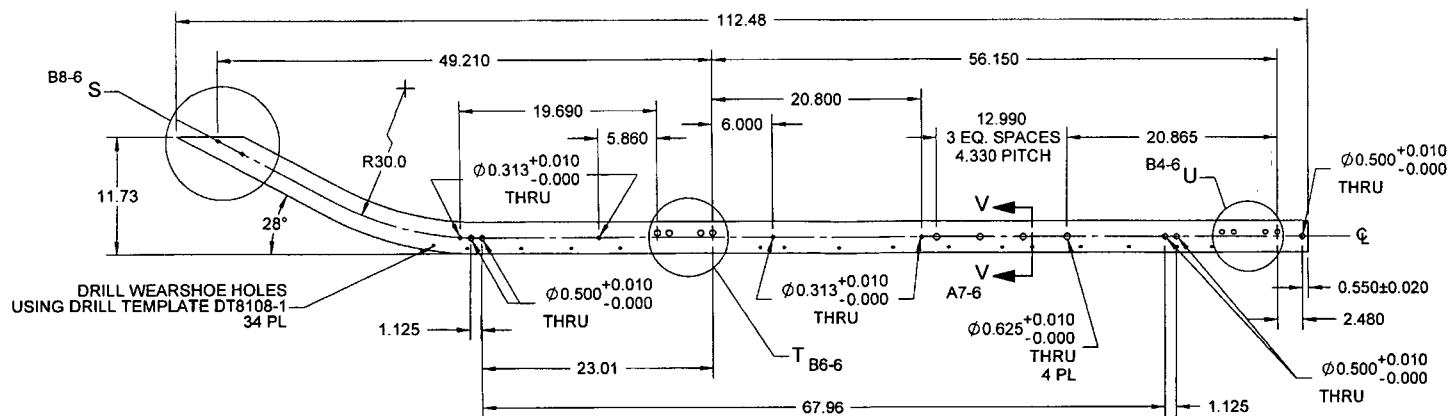
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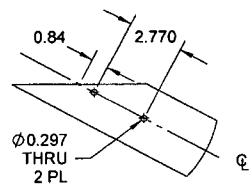
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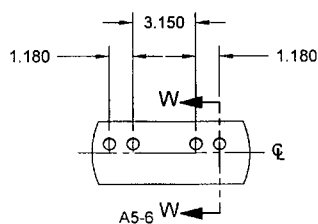
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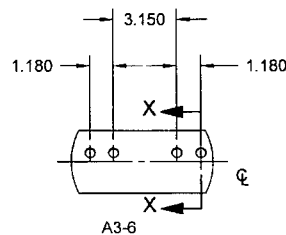
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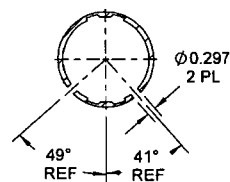
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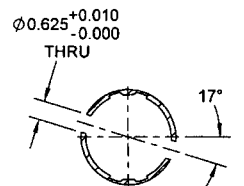
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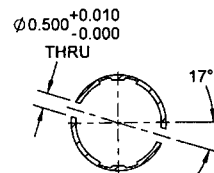
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SECTION V-V
SCALE 3X, 17 PL



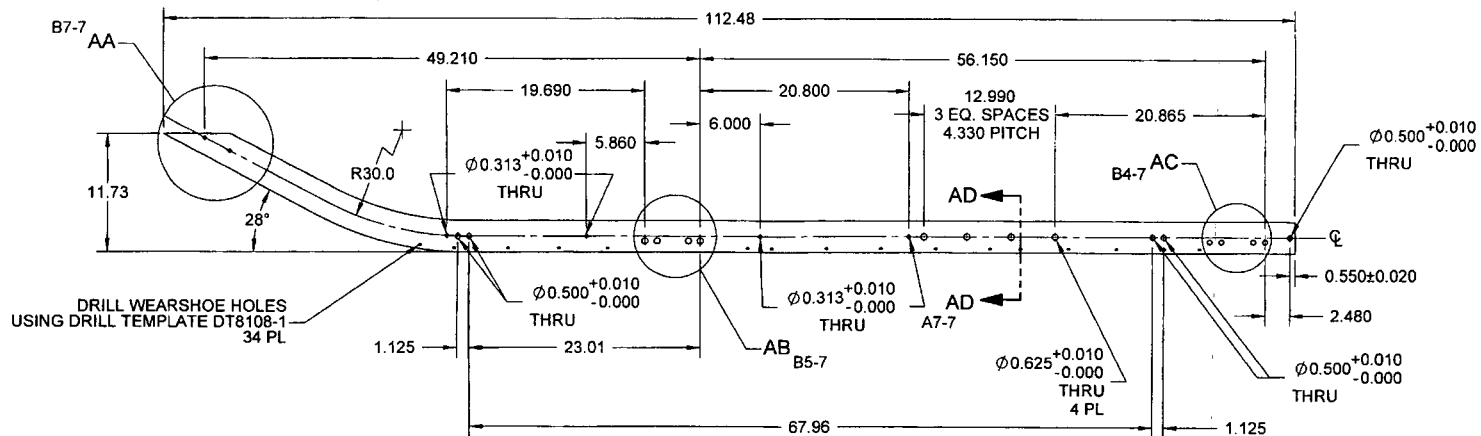
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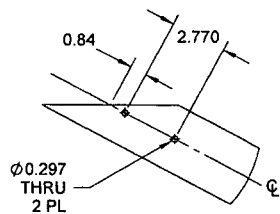
SECTION X-X
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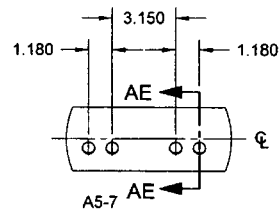
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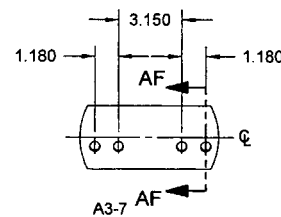
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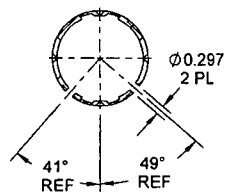
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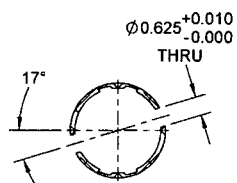
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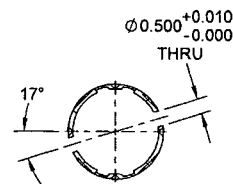
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SECTION AD-AD
SCALE 3X, 17 PL



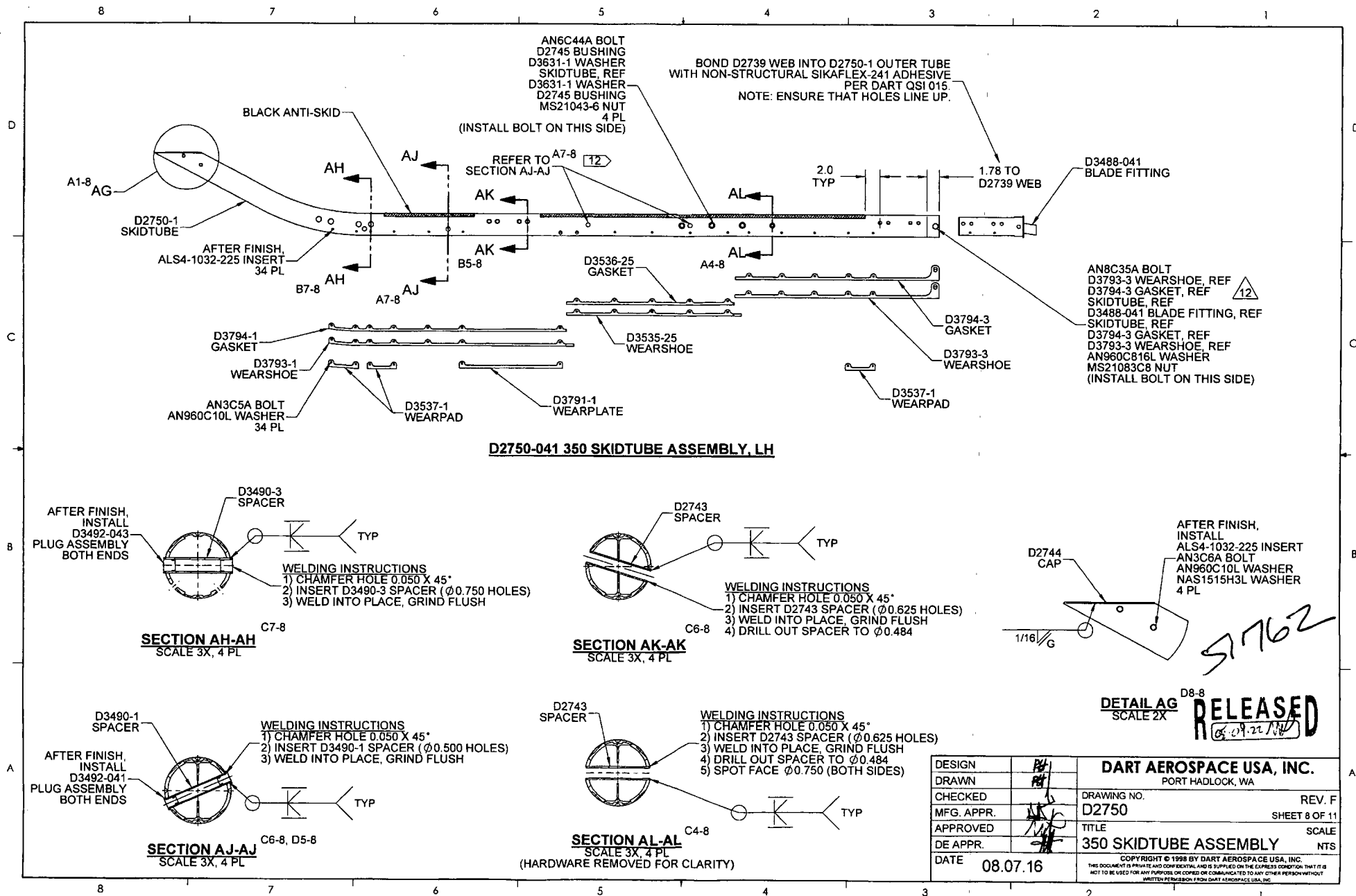
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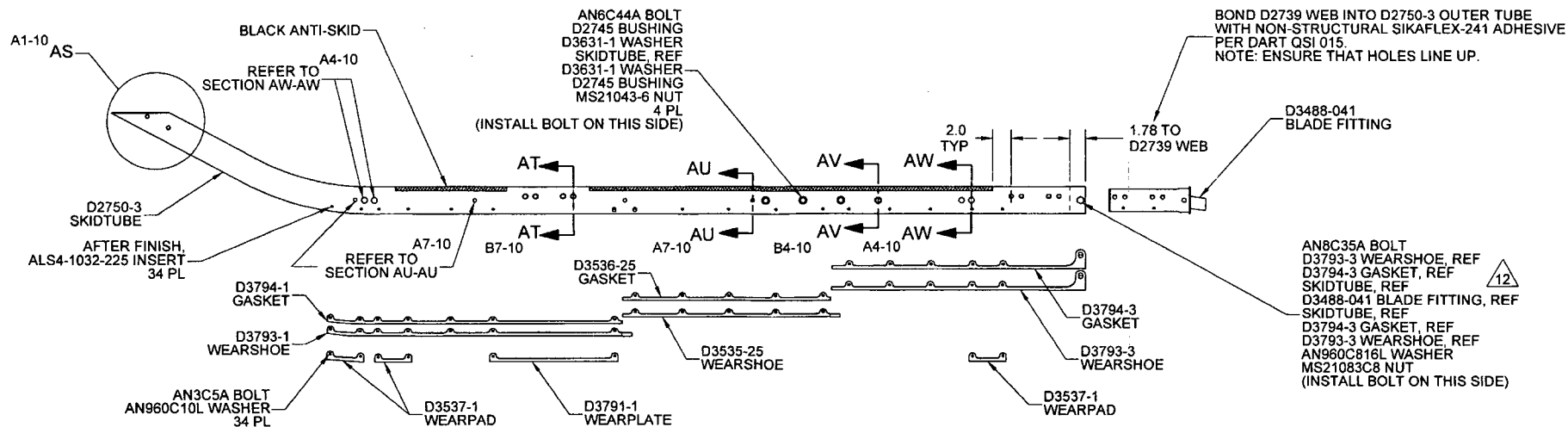


SECTION AF-AF
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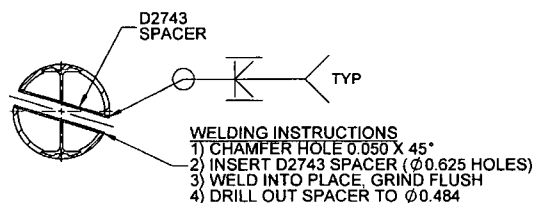
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06-09-22-118

DESIGN	PA	DART AEROSPACE USA, INC.	
DRAWN	PA	PORT HADLOCK, WA	
CHECKED	PA	DRAWING NO.	REV. F
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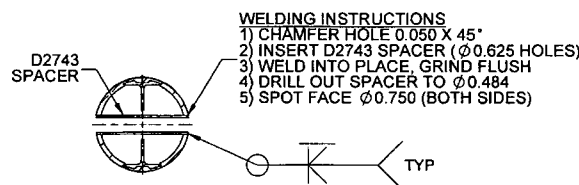




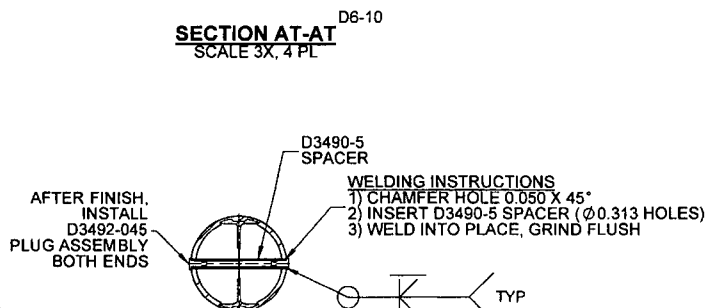
D2750-043 350 SKIDTUBE ASSEMBLY, LH



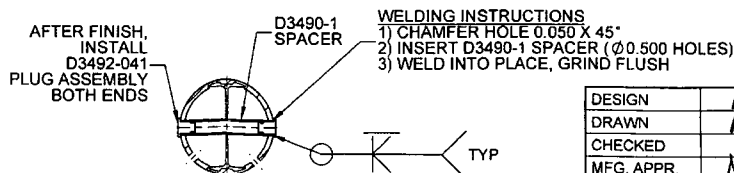
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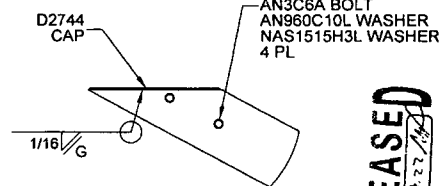
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SECTION AU-AU SCALE 3X, 4 PL



SECTION AW-AW SCALE 3X, 4 PL

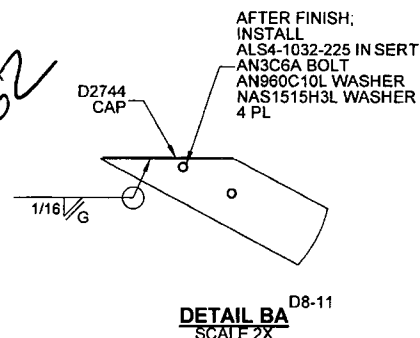
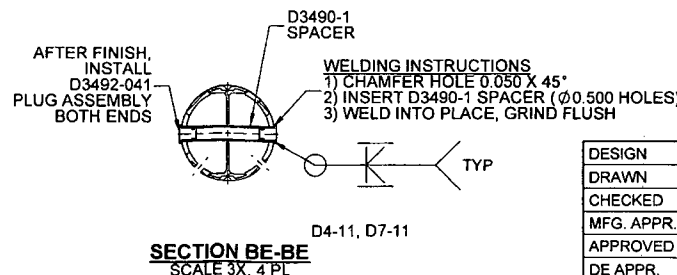
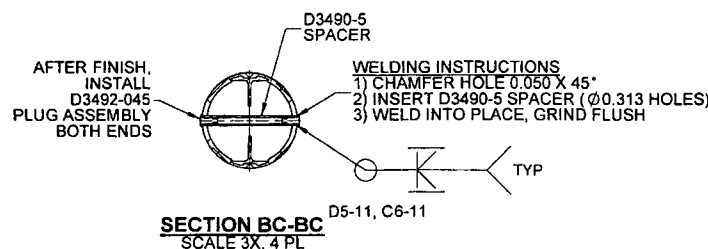
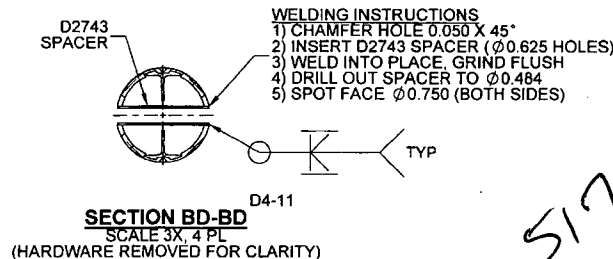
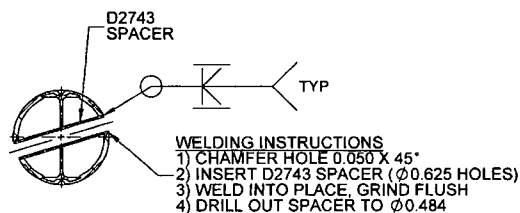
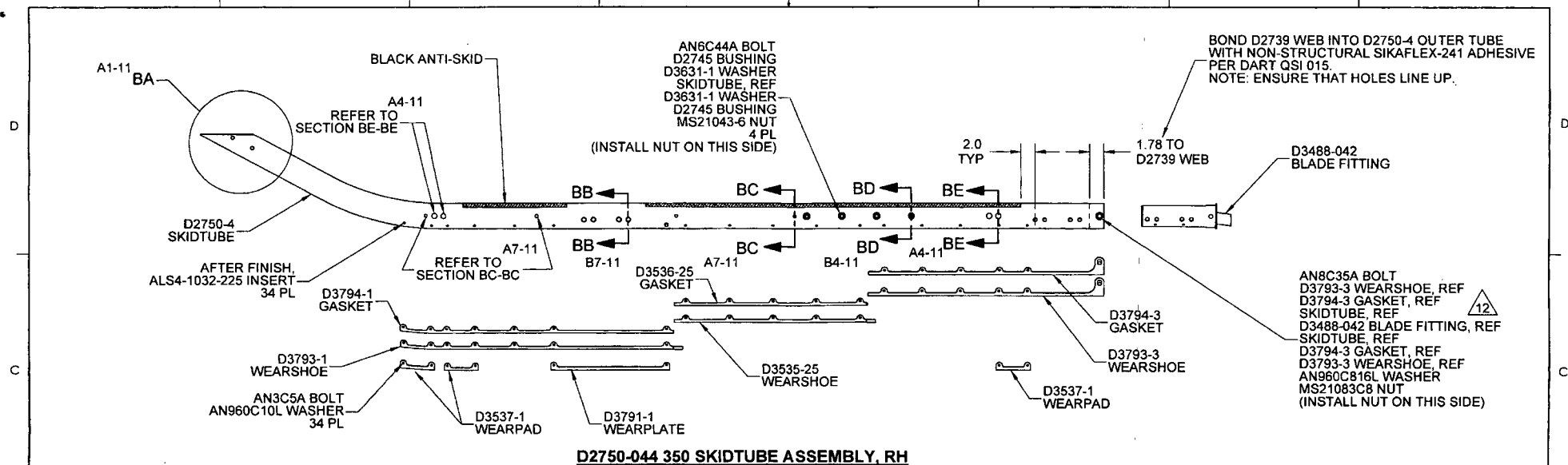


DETAIL AS SCALE 2X

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CHECKED		DRAWING NO.	REV. F
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APPROVED		TITLE	SCALE
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2008-08-27/10

8 7 6 5 4 3 2 1



DESIGN	REV. F	DART AEROSPACE USA, INC.	
DRAWN	REV. F	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 11 OF 11
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NO. 213

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 851620
Part number: 1350-636-Q12
Description: 350 SKid tube
Welding Process: Tig[☒] Mig[☐]
Base material: Alum
Current: AC[☒] DC[☐]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[☐]
Penetration: pass[☒] fail[☐]

UNACCEPTABLE

Cracks: pass[☒] fail[☐]
Undercut: pass[☒] fail[☐]
Pin holes: pass[☒] fail[☐]
Overlap (cold lap): pass[☒] fail[☐]
Porosity (surface): pass[☒] fail[☐]
Coloration: pass[☒] fail[☐]

Qualifier David Paul Date of Test Coupon 09/10/22
Welder Barclay Elliott Date of Test Coupon 09/10/22

The above named individual is qualified in accordance with AWS D17.1.2001 to weld